

Work Order ID 66662

Page 1

Wednesday, February 23, 2011 1:13:08 PM

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *CL*Date: *11/02/23* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3507

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

8 u/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Skidtubes	Skidtubes	0.00				1	0	BE11/03/14	
Skidtubes	Memo 1-Cut Aft end as per dwg D3507 2-Deburr ends 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open holes to 0.297" 9-Open Aft & Fwd Cap holes using .208" drill. 10-Bore out aft end of tube as per Dwg D3507 & Detail "B". 11-Open ground wire hole .297" section E-E 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.	0.00							

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulog/14



150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 B 11/03/05

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 O BEL/03/15

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 116040
Exp Date: 11/09/20
start time: 8:30
end time: 4:00

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D:

A/R AL ROD Batch: M111385 BE 11/03/14

6-Grind welds flush

BE 11/03/16

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

> BE 11/03/17

8-Deburr Rivet holes.

BB 11/03/15

W/O:		WORK ORDER CHANGES					
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Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
190 Skidtubes Skidtubes	Skidtubes Memo 1-Rivct D3506-1/-3 as per Dwg D3507.	0.00 0.00							
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

8/10/03/17

②

1 0 BE 11/03/17

8/10/03/17

⑦

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BL 11-3-18

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 115951

Memo

0.00

Powder Coating

START TIME: 11:15
OVEN TEMPERATURE: 320°
FINISH TIME: 11:45

1 BL 11-3-18

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ M 1103121

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____



Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	HandFinishing	0.00							
 HandFinish									
Hand Finishing	↳ Memo Install Wearplate & Ground Wire inserts as per Dwg D3507.	0.00							
250	QC5- Inspect part completeness to step on W/O	0.00							
 QC									
Quality Control	Memo Inspect Inserts	0.00							

1 0 11/03/22

8 11/04/22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00

Customer:



Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
	✓ 1-Inspect for Foreign objects								
	2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"								
	A/R 241 Sika Flex Batch: <u>11116040</u>								
	Exp Date: <u>1109</u>								
	✓ 3-Install Wearplates as per Dwg D3507,								
	Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube								
	Do not Install Scews where indicated on Dwg(Note #6)								
	A/R 241 Sika Flex Batch: <u>11116040</u>								
	Exp Date: <u>1109</u>								
	✓ 4-Install Plug assemblies with lubricate as per Dwg D3507.								
	Batch: <u>11114189</u>								
	✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4								
	Batch: <u>11116402</u>								
270	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

8/10/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280  Packaging	Pick Kit	0.00							
Packaging	Memo	0.00							
290  QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							
300  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>8</u>								
	PPP Rev: <u>8</u>								

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Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start


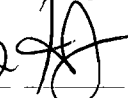


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/3/22	 mk 11-03-22

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 23, 2011 1:13:02 PM

Page 1

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation






Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-I-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3507-I-BENT  Skidtube Assembly EC135		Manufactured	No			120	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>2</div> <div></div> </div>													
<div> <div>62291</div> <div>1</div> <div></div> </div>													
<div> <div>62292</div> <div>1</div> <div></div> </div>													
D3504-1  Crossbolt Spacer		Manufactured	No			170	Each	18.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>18</div> <div></div> </div>													
<div> <div>53742</div> <div>18</div> <div></div> </div>													
D3504-3  Crossbolt Spacer		Manufactured	No			170	Each	30.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>30</div> <div></div> </div>													
<div> <div>31232</div> <div>10</div> <div></div> </div>													
<div> <div>53743</div> <div>20</div> <div></div> </div>													

BE 11/03/14
 B67132 *1

BE 11/03/14

BE 11/03/14

1

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Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-5 Manufactured No 170 Each 18.0000 2 2



Crossbolt Spacer



BE 11/03/10

Location Loc Qty Loc Code

LG 18

36181 2

53744 16

D3505-1 Manufactured No 170 Each 0.0000 1 1



Web



BB 11/03/15

D3506-1 Manufactured No 190 Each 70.0000 4 4



Doubler



BE 11/03/17

Location Loc Qty Loc Code

ST066 70

51789 70

D3506-3 Manufactured No 190 Each 66.0000 2 2



Doubler



BE 11/03/17

Location Loc Qty Loc Code

ST066 66

51790 66

MS20601-AD4W3 Purchased No 190 Each 3,523.000 12 12



Rivet



BE 11/03/17

Location Loc Qty Loc Code

ST321 3523

114538 3523

12

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

240

Each

1,814.000

38

38



Insert



HL 11/03/21

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1793

111529

32

113238

17

115502

500

115581

244

116800

1000

X38

ALS4-1032-225

Purchased

No

260

Each

4,015.000

1

1



Insert



HL 11/03/21

Location

Loc Qty

Loc Code

PK011

4015

110768

4015

V1

AN3C4A

Purchased

No

260

Each

2,296.000

31

31



BOLT



HL 11/03/21

Location

Loc Qty

Loc Code

ST350

2296

115300

25

116075

337

116704

734

116924

1200

y31

W/O:		WORK ORDER CHANGES					
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• H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

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Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 2/23/2011



Required Date: 3/4/2011

Start Qty: 1.00



Required Qty: 1.00

AN3C5A Purchased No 260 Each 1,024.000 2 2

 Bolt  41103121

Location	Loc Qty	Loc Code
ST350	1024	
107862	68	
108302	34	
114330	11	
115015	13	
115371	4	
115422	100	
<u>115835</u>	194	<u>x2</u>
116419	500	
116549	100	

AN526C1032R10 Purchased No 260 Each 402.0000 2 2

 Screw  41103121

Location	Loc Qty	Loc Code
ST327	100	
114494	100	
ST328	302	
<u>108062</u>	126	<u>v2</u>
110049	176	

AN960C10L NAS1149C0332 Purchased No 260 Each 127.0000 33 33

 washer  41103121

Location	Loc Qty	Loc Code
ST245	127	
107534	59	<u>11163041</u>
108246	68	<u>x33</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:13:03 PM

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

35.0000

1

1



Cap, 105 Skidtube



yl

11/03/21

Location

Loc Qty

Loc Code

FP4

35

52057

35

x1

Manufactured No

260

Each

7.0000

1

1

D2965-3



Cap



yl

11/03/21

Location

Loc Qty

Loc Code

FP

7

50560

3

B46582

x1

52282

4

Manufactured No

260

Each

93.0000

4

4

D3492-041



Plug Assembly



yl

11/03/21

Location

Loc Qty

Loc Code

FP013

93

59114

1

62210

3

63994

29

65068

60

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:13:04 PM

Page 6

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043 Manufactured No 260 Each 41.0000 4 4
Plug Assembly
ME 11/03/21

Location	Loc Qty	Loc Code
FP	2	BGG650
54682	2	
FP013	39	
59117	1	
59190	4	
63996	2	
65070	32	

D3492-047 Manufactured No 260 Each 37.0000 2 2
Plug Assembly
ME 11/03/21

Location	Loc Qty	Loc Code
FP	37	
28961	26	
39722	11	

D3508-1 Manufactured No 260 Each 19.0000 1 1
Wearplate
ME 11/03/21

Location	Loc Qty	Loc Code
FP	5	
42973	1	
51261	4	
FP-16	14	
61020	14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, February 23, 2011 1:13:04 PM

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3 Manufactured No

260

Each

10.0000

1

1



Wearplate



24 11/03/21

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

9

62882

3

65192

6

X1

D3508-5 Manufactured No

260

Each

5.0000

1

1



Wearplate



24 11/03/21

Location

Loc Qty

Loc Code

FP

1

42251

1

FP21

4

51388

4

X1

D3508-7 Manufactured No

260

Each

3.0000

1

1



Wearplate



24 11/03/21

Location

Loc Qty

Loc Code

FP

1

31198

1

FP21

2

60336

2

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:13:04 PM

Work Order ID: 66662

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 2/23/2011



Required Date: 3/4/2011

Start Qty: 1.00



Required Qty: 1.00

D3558-1	Manufactured	No	260	Each	16.0000	1	1
							<u>11/03/21</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	16	
42533	1	<u>x 1</u>
50925	15	

D3558-3	Manufactured	No	260	Each	6.0000	1	1
							<u>11/03/21</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	6	<u>x 1</u>
42253	1	
55468	5	

D3558-5	Manufactured	No	260	Each	6.0000	1	1
							<u>11/03/22</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	6	
43244	1	<u>x 1</u>
50926	5	

D3558-7	Manufactured	No	260	Each	3.0000	1	1
							<u>11/03/22</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	3	
43245	1	<u>x 1</u>
50927	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:13:04 PM

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

440.0000

2

2



O-RING



ML 4/03/22

Location

Loc Qty

Loc Code

FP

440

103697

440

x2

NAS1611-010

Purchased

No

260

Each

309.0000

4

4



O-RING



ML 4/03/22

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

x4

NAS1611-013

Purchased

No

260

Each

248.0000

4

4



O-RING



ML 4/03/22

Location

Loc Qty

Loc Code

FP

248

115460

100

115589

28

115812

20

116582

100

x4

AN3C4A

Purchased

No

280

Each

2,296.000

8

8



BOLT



4/13/22

Location

Loc Qty

Loc Code

ST350

2296

115300

25

116075

337

116704

734

116924

1200

11/6925

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, February 23, 2011 1:13:05 PM

Work Order ID: 66662

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

280

Each

127.0000

8

8



washer



11/6807

Location

Loc Qty

Loc Code

ST245

127

107534

59

108246

68

D3512-1

Manufactured No

280

Each

5.0000

2

2



Wearplate



67169 11/3/22

Location

Loc Qty

Loc Code

ST500

5

63954

5

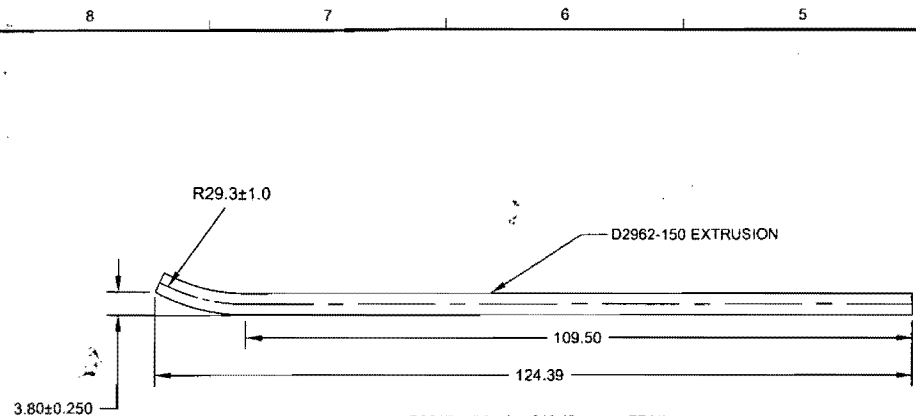
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

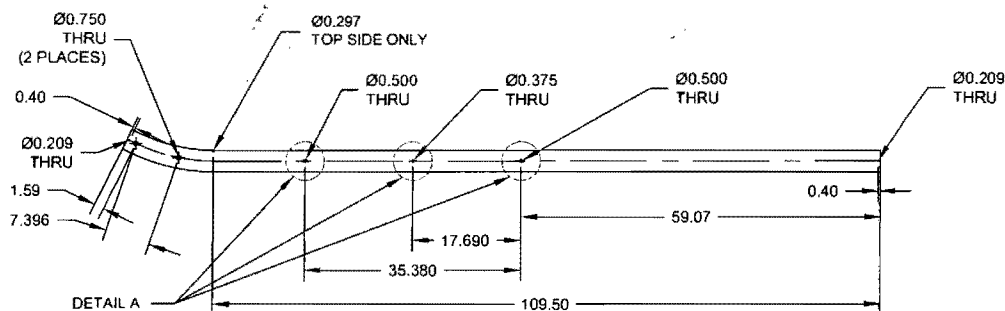
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

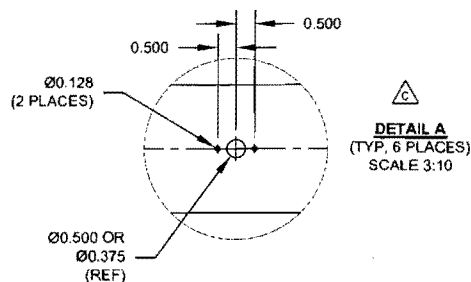
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 666662
C211102123

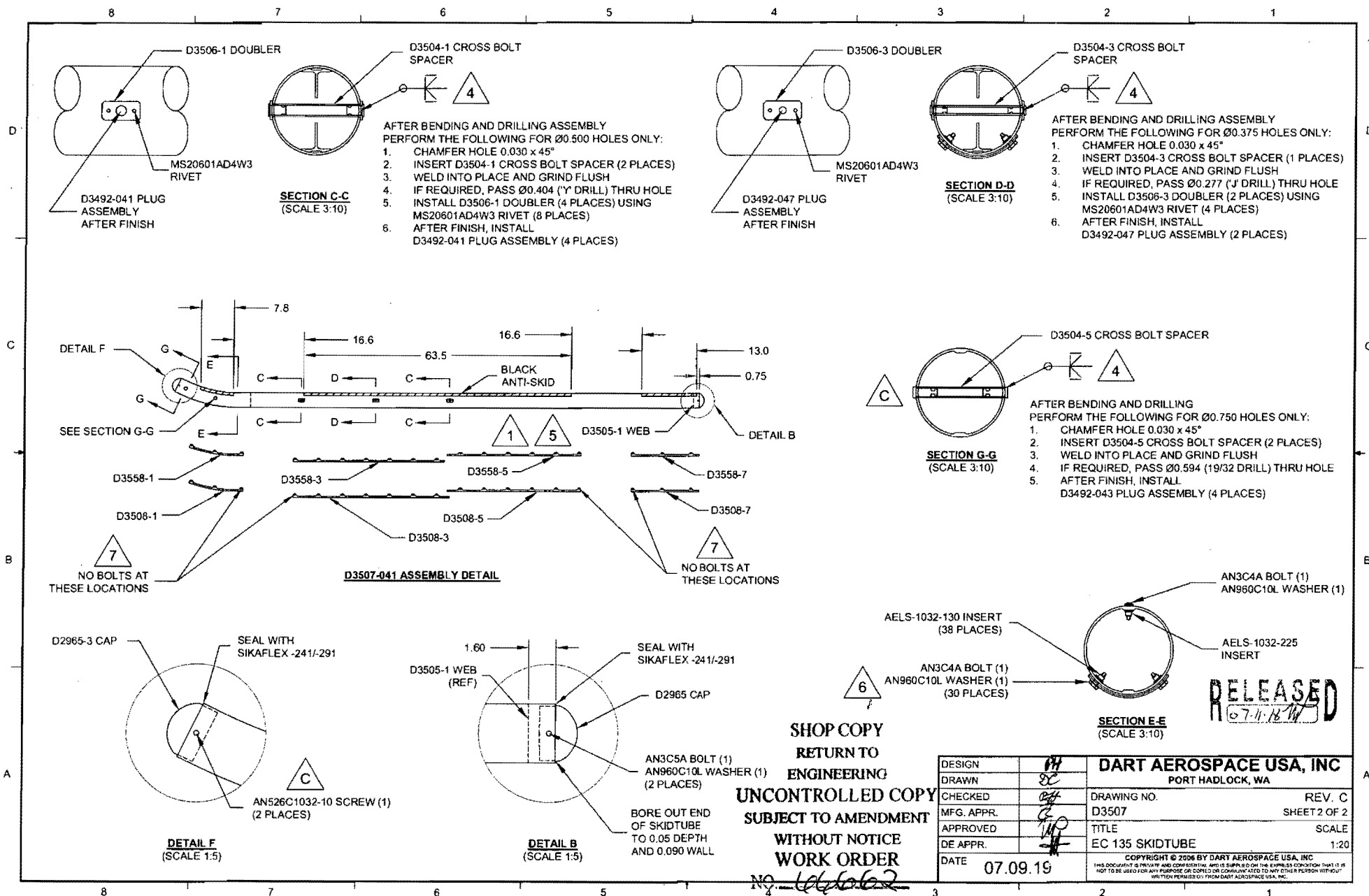
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	05.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PC	PORT HADLOCK, WA	
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BE	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

RELEASED
07.11.16



NO. 247

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 66661
Part number: D135-751-011
Description: 135 skid truck
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[] fail[]

Qualifier: Pat Jones Date of Test Coupon 11/03/17
Welder: Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld